DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028587
Date Inspected: 09-Oct-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1930
Location: Job site

CWI Name: Patrick Swain

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

The QAI observed ABF/JV qualified welder Rick Clayborn #2773 performing Carbon Arc Gouging (CAG) for the repair of the longitudinal deck drop-in weld designated as 13W-W2.1 from face B. The ABF/JV QC inspector Patrick Swain was observed performing magnetic particle testing (MT) in way of the repair excavations at the following locations,

13W-W2.1
Y=5180 (Face B), Depth 12, Width 65mm, Length 120mm
Y=7485 (Face B), Depth 8, Width 20mm, Length 85mm
Y=7910 (Face B), Depth 13, Width 75mm, Length 145mm
Y=9250 (Face B), Depth 13, Width 75mm, Length 120mm

The ABF qualified welder Rick Clayborn #2773 was observed later in the shift performing Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair at the above mentioned location. The weld and surrounding area was brought to a temperature of 325ºF by the use of induction heaters and maintained throughout the welding process. The repairs were then observed to be post heated at 450ºF for one hour as required by the applicable repair document. The repairs were performed in accordance with the following approval for repair documents;

Y=5180 RWR201209-111
Y=7485 RWR201209-105
Y=7910 RWR201209-112
Y=9250 RWR201209-113

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) deck drop-in weld connections for lift 13E. The welds were previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;

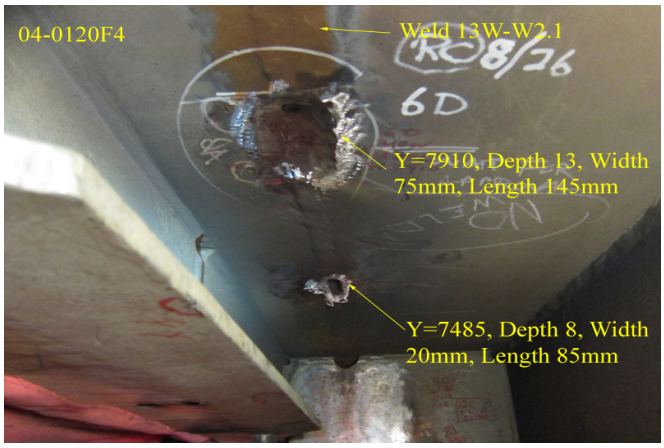
Lift 13E Edge Plate Splice (Weld No. 13E-PP121.6-G)
The QAI performed a minimum of 100% verification of this weld from face A only. No rejectable indications were observed at the time of inspection.

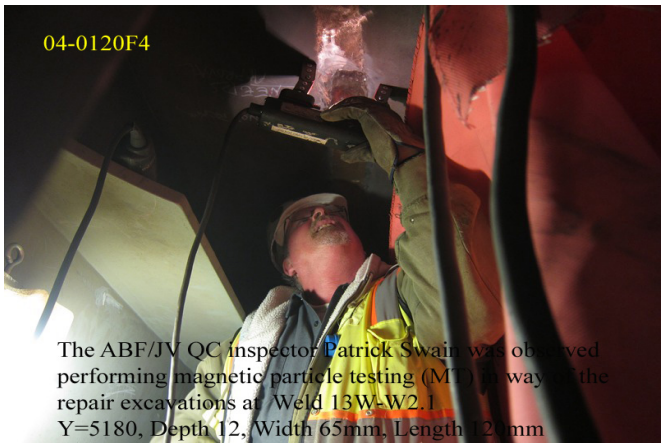
Magnetic Particle Testing (OBG 13E)
This QA Inspector performed verification Magnetic Particle Testing (MT) of the lift 13E edge plate splice at panel point 121.6. This QA Inspector generated a TL-6028 MT report on this date. The results of the inspection are as follows;

Lift 13E Edge plate splice (Weld No. 13E-PP121.6-G)
The QAI performed 100% verification of this weld from face A only, due to a slice plate attached to the B face of this weld connection. No rejectable indications were observed at the time of inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
Conversations relevant to the work being performed.





Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for

your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer